

Work Order ID 78609

78609

Page 1

January-11-12 2:47:28 PM

Item ID: D2348

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate

Start Date: 11/01/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 25/01/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 12/01/11

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2348	Rev C								

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2348

Dwg Rev: EProg Rev: E

2-Deburr if necessary

B12-3-9

110

0.00

110

QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B12-3-9

120

0.00

120

QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

87103109carb
422

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78609

January-11-12 2:47:28 PM

N900040100

Setup Start *NS1*

Stop *NS2*

12

Cust Item ID:

12

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

150	Outsource process-Anodize per OSI017 4.1.10.1	0.00
-----	---	------

0.00

Outsource4

Outsource process - Anodize

Memo

Issue P/O: 16434

Black Anodize per Dwg D2348

Ensure Certificate of Conformity is attached

160

Receive & Inspect for Damage & Mat'l Certs	0.00
--	------

0.00

Packaging

Packaging

Memo

Ensure certificate of conformity is attached

170

QC5- Inspect part completeness to step on W/O	0.00
---	------

0.00

QC

Quality Control

Memo

INSPECT CERTS

W/O:		WORK ORDER CHANGES					
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Item ID: D2348 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wearplate
 Start Date: 11/01/2012 Start Qty: 12.00 *12* Cust Item ID:
 Required Date: 25/01/2012 Req'd Qty: 12.00 *12* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00				22X			
180	Small Fab					22X			
Small Fab	Memo	0.00							
Small Fab	Install Insert as per Dwg D2348								SP 12/04/10
190	QC5- Inspect part completeness to step on W/O	0.00							
190									
QC	Memo	0.00				Locates			
Quality Control						(422)			
200	Identify as per dwg & Stock Location	0.00							
200									
Packaging	Memo	0.00							
Packaging						22X			SP 12-04-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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January-11-12 2:47:28 PM

Item ID: D2348 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Wearplate
Start Date: 11/01/2012 Start Qty: 12.00 *12* Cust Item ID:
Required Date: 25/01/2012 Req'd Qty: 12.00 *12* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC21- Final Inspection - Work Order Release	0.00							
210									
QC	Memo	0.00							
Quality Control									

12/4/12

12-04-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

January-11-12 2:47:32 PM

Page 1

Work Order ID: 78609

78609

Parent Item: D2348

D2348

Parent Item Name: Wearplate

Start Date: 11/01/2012

Required Date: 25/01/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev A Removed from 9 Digit 05-12-05 JLM
IPP Rev:B Now on Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.063

Purchased

No

100

sf

162.0696

0.0198

0.250105

✓

M6061T6S 063

6061-T6 .063 Sheet

**

B12-3-8

Location

Loc Qty

Loc Code

MAT021

162.0695684

113608

0

116308

11.9555684

117285

75.414

119331

49.2

119802

25.5

116308

22

D3996-FE-832-EF

Manufactured

No

180

Each

131.0000

4

48

D3996-FE-832-EF

Self-Clinching Fastener

**

9/5/2/04/10

Location

Loc Qty

Loc Code

GA

100

77489

100

ST285

31

71756

31

B82502

88

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

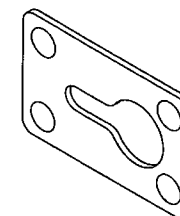
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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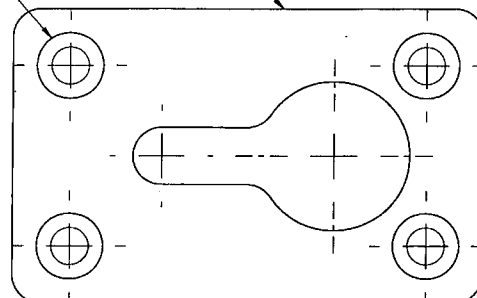
NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D2348	WEAR PLATE
2	1	D2348F	FLAT PATTERN
3	4	D3996-FE-832-EF	SELF-CLINCHING FASTENER



D3996-FE-832-EF
SELF-CLINCHING FASTENER
4 PL

D2348F



D2348 WEAR PLATE

SHOWN
REVISION
ENGINEER
UNCONTROLLED
SUBJECT TO

WITH
WORK
NO. 78609 M.C.J

12/01/11

RELEASED
2009-11-09

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

C	REDRAW, ADD +0.003/-0.000 TOL (ZN D4-2), NCR 08-042	CP	09.10.01
B2	CHANGED BACK TO 6061-T6	DS	02.02.21
B1	CHANGED TO AISI 304/316 MATERIAL	DS	00.03.07
B	CHANGED PEM INSERT TO 8-32	BW	95.02.20
REV.	DESCRIPTION	BY	DATE
DESIGN	BW		
DRAWN	97		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.10.01		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D2348** REV. C
SHEET 1 OF 2

TITLE **WEAR PLATE** SCALE NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

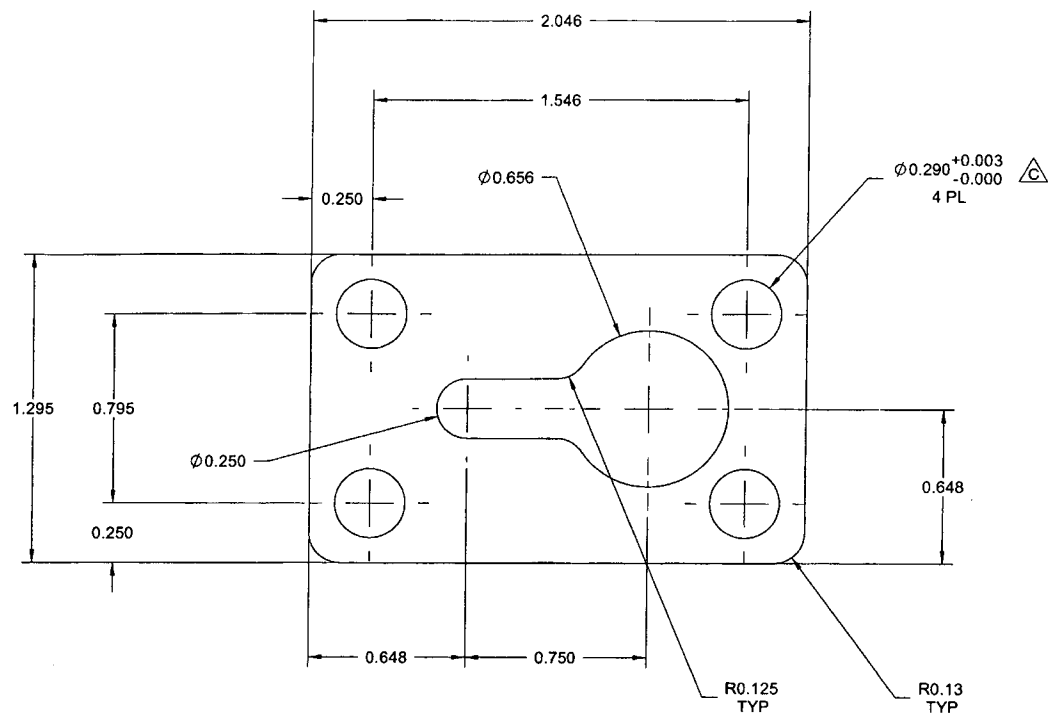
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78609



D2348F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET 0.063 THICK PER QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I/II/III CLASS 2
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D2348F" USING REMOVABLE TAG
- 7) WEIGHT: 0.01 lbs

RELEASED
2009-11-08
MD

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	LS	DRAWING NO.	REV. C
MFG. APPR.	MD	D2348	SHEET 2 OF 2
APPROVED	MD	TITLE	SCALE
DE APPR.	MD	WEAR PLATE	NTS
DATE	09.10.01	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO16434

Purchase Order Date 3/14/12

PO Print Date 3/14/12

Page Number 1 of 1

Order From :

VC-AND002

ANODIZING & PAINT T.N.M. INC.
21 AVIATION ROAD
POINTE CLAIRE, QC H9R 4Z2
CA

Contact Name

Vendor Phone

Vendor Fax

Vendor Account Nbr

514 429 7777

514 429 5108

Buyer

Requisition Nbr

Tax Resale Nbr

Terms

Currency

FOB

Chantal Lavoie

10127-2607

Net 30

CAD

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
03/14/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	78609	D2348 WEARPLATE	3/23/12 Yes	22.00	FedEx PI collect	\$4.5500	\$100.10

Special Inst: BLACK ANODIZE AS PER: MIL-A-8625F
TYPE I/IB/IC/II/IIB CLASS 2

PO Total:

\$100.10

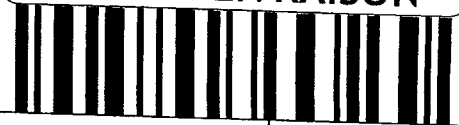
Change Nbr: 1

Change Date: 3/14/12

CL
No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



SHIPPING ADVICE BON DE LIVRAISON



C of C Number : 211734

Customer

DART AEROSPACE

1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
TEL # 613-632-9577
FAX # 613-632-1053

Shipping Address

1270 ABERDEEN STREET
HAWKESBURY, ON K6A 1K7
TEL # 613-632-9577
FAX # 613-632-1053

PO Number: 16434

Cert Rev: 0

Ship date: 2012-03-27

C of C Generator: Waqas

LINE ITEM DETAIL - PARTS DESCRIPTION

Item #	Part Number	Dash	Serial Number	Lot/Batch Number	PO Line Item #	Rec	Rej	Ship	Additional Information
1	TEmples BLACK ANODIZE MIL-8625				001	22	0	22	Refer to C of C for specific details
2	TEmples BLACK ANODIZE MIL-8625			MINIMUM CHARGE		1	0	1	

Transport/FOB Point:

Siddhanta

I hereby take possession of the goods mentioned above and acknowledge that parts are packaged properly and no visual damage is apparent on parts / Packaging.
Je prends possession des biens ci-haut mentionnés et confirme que les pièces ont été emballées de façon adéquate et ne présente pas de dommage apparent aux pièces / emballage.

Signature: _____

Date: _____

Template Name / Rev: Shipping Advise rev X



CERTIFICATE OF CONFORMITY CERTIFICAT DE CONFORMITÉ



C of C Number : 211734

Cert Rev	0	DWG Rev	
Page:	1 of 1		
C of C date	27 Mar 2012		
PO Number :	16434		

C of C Generator	Waqas
Material	

Customer
DART AEROSPACE 1270 ABERDEEN STREET HAWKESBURY, ON K6A 1K7 TEL # 613-632-9577 FAX # 613-632-1053

LINE ITEM DETAIL - PARTS DESCRIPTION

Item #	Part Number	Dash	Serial Number	Lot/Batch Number	PO Line Item #	Rec	Rej	Ship	Additional Information
1	TEmples BLACK ANODIZE MIL-8625				001	22	0	22	D2348, B 78609 WEAR PLATE

THE FOLLOWING PROCESS(ES) WERE APPLIED TO THE COMPONENTS MENTIONED ABOVE

#	Required Process Name	Spec Number	Rev.	Process description
1	Sulphuric Acid Anodize Per MIL-A-8625 BLACK	MIL-A-8625	F, AMENDMENT 1	BLACK ANODIZE PER MIL-A-8625 rev F1 TYPE II CLASS 2

Customer Additional Info:

This certifies that all parts are processed, tested and inspected to the requirements of the above requirements / Specification.
 Travel Card have been completed, filed and are available for review upon request.
 Nous certifions que les Pièces énumérées ci-haut ont été traitées et inspectées selon les requis / Spécifications mentionnés.
 Les feuilles de Route (Travel card) ont été complétées, classées et sont disponibles pour consultation sur demande.
 Importante Notice: Painted Parts will be Fully Solvent Resistant after 7(seven) Full Days of Air Curing at Ambient Temperatures. Any modification/Rework to the components without express written agreement from TNM will invalidate this certificate.
 Notice importante: Les pièces peintes seront complètement résistantes au solvant après 7(sept) jours complets de séchage à l'air ambiant. Quelques Modifications / Réparations que ce soit, faites aux composantes, sans le consentement écrit de TNM invalideront ce Certificat.

Signature:

Stamp:



Date:

03/27/12

Template Name/Rev: Certificate of Conformity Rev X